

Work Order ID 85765

Thursday, June 14, 2012 2:46:42 PM

85765

ASPD

Page 1

Item ID: D4170-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bushing

Stop ***NS2***

Start Date: 6/14/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/18/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: UMF

Date: 12-06-14 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4170	B

100 0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per Folio FA989

FOLIO REV: B

DWG REV: B

DEBURR

SL 12/6/15

14 ϕ

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SL 12/6/15

14 ϕ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Jul 12-06-15 14

125

0.00

125

Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

14 CF 12-6-15

130

Identify as per dwg & Stock Location: *104*

0.00

130

Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

14x 12/6/15

Dart Aerospace Ltd

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Picklist Print

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Page 1

Work Order ID: 85765

Parent Item: D4170-3

Parent Item Name: Bushing

Start Date: 6/14/2012

Required Date: 6/18/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-10-28 JLM VERIFIED BY:DD IPP Rev:A 10.11.02 as per
revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 6061-T6 Round Bar .500"		Purchased	No			100	f	117.3680	0.275	3.4736842			

Location

Loc Qty

Loc Code

MAT012

117.368

114488

1.997

117379

9.288

119043

106.083

SD 126/15

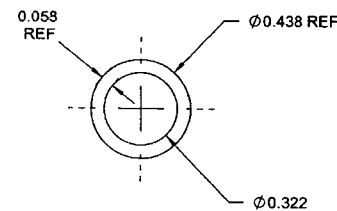
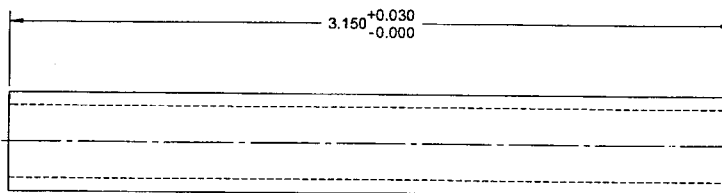
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NOTE: Date & initial all entries



85765

D4170-3 SPACER

RELEASED
2010-11-01

NOTES:

- 1) MATERIAL: 6061-T6 ROUND BAR, Ø7/16 OD
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221
REF DART SPEC. M6061T6R0.438
- OR
6061-T6 OR 6061-T62 TUBING, Ø7/16 OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/6, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.438W.058
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4170	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
DATE	10.10.25	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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